

# Work Order ID 70717

Monday, June 27, 2011 1:37:01 PM

Page 1

Item ID: D206-642-411

Accept

Revision ID:

Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00

Required Date: 6/14/2011 Req'd Qty: 1.00

Reference: RMA RA111225 - RETURN - Rework

Cust Item ID:

Customer: CU-DAR001

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

M

0.00

0.00

100

QC

Quality Control

Memo

INSPECT RETURN RA 111225  
D206-642-411 B 41103

CHG004

Subdel 27

<b>DART</b>				TEL: 1-613-632-8336	
TRANSPORT CANADA APPROVAL 4-09-89				FAX: 1-613-632-4443	
PN	D206-642-411	CHG	CHG004		
DESC	Skidtube LH High	STC	SH98-4		
LOT	B41103	SIC	SA00475SE		
MODEL	Bell 206L/L1/L3/L4	STC			
PATENT # 5735484				MADE IN CANADA	
ADA FOREIGN PATENTS PENDING					

D206-642-441  
B41103A

B 70717

# Work Order ID 70717



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Item ID: D206-642-411

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111225

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



HandFinish

Memo

0.00

Hand Finishing

REMOVE D2646 AND SCRAP  
REPLACE WITH NEW D2646 B 62676

REMOVE OLD WEAR PLATES AND REPLACE PER DSI 9440

REMOVE AND RETURN TO STK

D2648-3 X 6 B 64278 (4) 870686 (X2)

D3429-1 X 1 B

D2656-15 X 1 B

D2656-23 X 1 B

D2656-37 X 1 B

MS27039-1-08 X 60 (SCRAP)

AN960JD10L X 60 (SCRAP)

REPLACE:

D3537-1 X 6 B 69278 (4x) 1370686 (X2)

D3537-3 X 1 B 70817

D3535-15 X 1 B 66558

D3536-15 X 1 B 66559

D3535-23 X 1 B 67594

D3536-23 X 1 B 66560

D3535-37 X 1 B 67612

D3536-37 X 1 B 63237

MS27039-1C08 X 60 B 1A17291

AN960C10L X 60 B 1118174

1 6 24 1107108

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Item ID: D206-642-411

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Revision ID:

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Start Date: 6/13/2011 Start Qty: 1.00

Required Date: 6/14/2011 Req'd Qty: 1.00

Reference: RMA RA111225

Cust Item ID:

Customer: CU-DAR001

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

0.00 8/16/09



QC

Memo

Quality Control

**Work Order ID 70717**

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Item ID: D206-642-411

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111225

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

**Memo**

0.00

RETURN ALL HARDWARE TO STOCK AND PULL NEW HARDWARE

PER IIN @ CHG 006

RETURN TO STOCK:

1 x D206-648-011 B39176 ✓

1 X D2655 B37378 ✓

1 X D2968-043 B37380 ✓

1 X AN4-5A B106605 ✓

1 X AN960JD1016 B5519 ✓

1 X AN970-4 B108377 ✓

**ADD TO KIT:**

1 X AN4C5A B \_\_\_\_\_

1 X AN960C416 B \_\_\_\_\_

1 X AN960JD416 B \_\_\_\_\_

1 X D206-648-013 B \_\_\_\_\_

1 X D3407-043 B \_\_\_\_\_

1 X D3413-1 B \_\_\_\_\_

1 X D3456-1 B \_\_\_\_\_

2 X D3457-1 B \_\_\_\_\_

1 X MS21042L4 B \_\_\_\_\_

1 X MS21043-4 B \_\_\_\_\_

*6/27/13**6/27/13*

# Work Order ID 70717

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Item ID: D206-642-411

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111225

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

CHC7006

0.00

Quality Control

150

0.00



Packaging

Memo

REPACKAGE PER PPP USING NEW BN  
@ CHG006  
NEW PAPERWORK & LABELS REQ'D

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8/11/19

200 F

for CL 11-7-12

11/7/19

11/7/19  
CME  
11-07-19

# Picklist Print

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Page 1

Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K 05.10.11 Revised picklist per CHG004 IKJ/CP/JLM  
IPP Rev:L 07-12-04 ECN 1080p DD verified by:ec  
IPP rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-5A		Purchased	No				Each	250.0000		-1			
--------	--	-----------	----	--	--	--	------	----------	--	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
ST355	200	
117508	200	
ST356	50	
116549	50	

M/106600 Lu

AN4C5A		Purchased	No				Each	515.0000		1			
--------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--



BOLT

Location	Loc Qty	Loc Code
FP-B	110	
112243	110	
ST345	405	
112243	405	

M/12243

AN960C10L	NAS1149C0332	Purchased	No				Each	0.0000		60			
-----------	--------------	-----------	----	--	--	--	------	--------	--	----	--	--	--



washer

X1118179

(x60) - M 1107108

AN960C416	NAS1149C0463	Purchased	No				Each	0.0000		1			
-----------	--------------	-----------	----	--	--	--	------	--------	--	---	--	--	--



washer

M/17730 (cup/120)

# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD1016 NAS1149C1063 Purchased No

Each 367.0000

-1



Washer



5519

*[Handwritten signature]*

Location

Loc Qty

Loc Code

MEZZ

367

5519

367

AN960JD416 NAS1149D0463J Purchased No

Each 0.0000

1



Washer



1117460

*[Handwritten signature]*

AN970-4 Purchased No

Each 395.0000

-1



Washer



108377

*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST342

383

117795

383

ST344

11

115936

11

ST349

1

116900

1

D206-642-411 Manufactured No

Each 4.0000

1



Skidtube LH



41103

*[Handwritten signature]*

Location

Loc Qty

Loc Code

FG

4

34556

1

34560

1

38777

1

38778

1

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# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D206-648-011 Manufactured No

Each

16.0000

-1



GHW Modification



39176

*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

FG120

16

39176

2

40442

4

41419

10

D206-648-013 Manufactured No

Each

8.0000

1



GHW Modification



70888

*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

FG120

8

68347

4

69933

2

70889

2

D2646 Manufactured No

Each

76.0000

1



Aft Cap



1107108

## Location

## Loc Qty

## Loc Code

FP004

60

68280

60

FP006

16

62678

16

D2648-3 Manufactured No

Each

6.0000

-6



Wearpad



X1

## Location

## Loc Qty

## Loc Code

FG

6

45316

6

40275

*[Handwritten signature]*  
11-07-29

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2656-15 Manufactured No

Each 0.0000

-1



Wearshoe

D2656-23 Manufactured No

Each 14.0000

-1



Wearshoe

Location

Loc Qty

Loc Code

MEZZ

14

34597

1

43407

5

51468

8

D2656-37 Manufactured No

Each 25.0000

-1



Wearshoe

Location

Loc Qty

Loc Code

MEZZ

25

44550

13

46497

1

53019

11

D3407-043 Manufactured No

Each 14.0000

1



Tow Ring

Location

Loc Qty

Loc Code

ST464

14

68339

2

69540

12

34596 x 1 ME 11-07-19  
34597 x 1 ME 11-07-19

34510 ME 11-07-19

6/17/13

69540

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# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

Each

19.0000

1



Ring

Location

Loc Qty

Loc Code

ST420

15

62961

8

66387

7

ST473

4

66945

4

62961

D3429-1

Manufactured No

Each

14.0000

-1



Wearpad

Location

Loc Qty

Loc Code

FP016

14

44579

14

40438 ME 11-0719

D3456-1

Manufactured No

Each

82.0000

1



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

75

66848

3

69774

22

71033

50

71033

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# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

Each

58.0000

1



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

48

67779

8

70774

40



70774

1

11/07/08

D3535-15

Manufactured No

Each

27.0000



Wearshoe

Location

Loc Qty

Loc Code

FP018

27

66558

7

68358

6

69931

14



11/07/08

D3535-23

Manufactured No

Each

17.0000



Wearshoe

Location

Loc Qty

Loc Code

FP021

17

66236

-1

67594

5

68342

13



11/07/08

D3535-37

Manufactured No

Each

3.0000



Wearshoe

Location

Loc Qty

Loc Code

FP018

3

67612

3



11/07/08

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# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15      Manufactured      No      Each      17.0000      1  
  u u/07/08  
 Gasket

Location      Loc Qty      Loc Code

FP011      17  
66559      17

D3536-23      Manufactured      No      Each      36.0000      1  
  u u/07/08  
 Gasket

Location      Loc Qty      Loc Code

FP011      36  
 43406      1  
 66560      9  
 69902      26

D3536-37      Manufactured      No      Each      16.0000      1  
  u u/07/08  
 Gasket

Location      Loc Qty      Loc Code

FP012      16  
63237      4  
 66823      12

D3537-1      Manufactured      No      Each      46.0000      6  
  u u/07/08  
 Wearpad

Location      Loc Qty      Loc Code

FP017      46  
69278      39  
69817      7

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

Each

4.0000

1



Wearpad



5d u107108

Location

Loc Qty

Loc Code

FP017

1

1370812

xl

35697

1

FP19

3

69292

3

Each

4,729.000

1

MS21042L4

Purchased

No



Nut



*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST300

4729

117441

2440

117601

789

117885

1500

Each

957.0000

1

117441

MS21043-4

Purchased

No



Nut



6/11/13

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

917

117601

417

117793

500

117601

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# Picklist Print

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Work Order ID: 70717

Parent Item: D206-642-411

Parent Item Name: Skidtube LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

Each

1,136.000

60



HL 11/07/08

SCREW

## Location

## Loc Qty

## Loc Code

FP-A

1

116022

1

ST293

1135

116373

3

117291

632

118077

500

✓ 60

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Shop Packet Print

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20410

Status	Item ID	Rev	Name	Quantity	Per	UOM	Stop Date	Route Seq ID	Scrap %	rap Quant	Comments	Date Last Mod
✓	AN3-41A ✓		Bolt	8.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN4-6A ✓		Bolt	12.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN4C5A Add		BOLT	1.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN5-11A ✓		Bolt	8.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN5-12A ✓		Bolt	4.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN5-13A ✓		Bolt	4.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN960C416 Add		washer	1.0000		Each			0 %	0.0000		11/17/2009 3:18...
✓	AN960JD10 ✓		Washer	8.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	AN960JD416 ✓ #1		Washer	24.0000		Each			0 %	0.0000		11/17/2009 10:4...
✓	AN960JD516 ✓		Washer	8.0000		Each			0 %	0.0000		11/13/2009 3:50...
✓	D206-642-441		Replacement...	1.0000		Each			0 %	0.0000		12/5/2009 6:12...
✓	D206-648-013 Add		GHW Modific...	1.0000		Each			0 %	0.0000		12/5/2009 8:19...
✓	D2652 ✓		Bushing	16.0000		Each			0 %	0.0000		12/5/2009 8:21...
✓	D2712 ✓		Set Screw	10.0000		Each			0 %	0.0000		12/5/2009 8:22...
✓	D2932-2 ✓		Saddle RH O...	1.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D2933-2 ✓		Saddle RH In...	1.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D2934 ✓		Saddle Spacer	2.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D2935 ✓		Saddle Spacer	2.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D2938-2 ✓		Saddle RH O...	1.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D2939-2 ✓		Saddle RH In...	1.0000		Each			0 %	0.0000		12/5/2009 8:23...
✓	D3407-043 add		Tow Ring	1.0000		Each			0 %	0.0000		12/5/2009 8:28...
✓	D3413-1		Ring	1.0000		Each			0 %	0.0000		12/5/2009 6:50...
✓	D3456-1 Add		Washer	1.0000		Each			0 %	0.0000		12/5/2009 8:28...
✓	D3457-1		Washer	2.0000		Each			0 %	0.0000		12/5/2009 8:28...
✓	MS21042L3 ✓		Nut	8.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	MS21042L4 ✓ #1		Nut	12.0000		Each			0 %	0.0000		6/24/2009 11:52...
✓	MS21043-4 Add		Nut	1.0000		Each			0 %	0.0000		6/24/2009 11:52...

412

# **RA 111225 D206-642-411 B41103**

## **CHG004**

### **Instructions to put skid tube back into stock**

- Remove (SCRAP) D2646 and replace with new one B# \_\_\_\_\_
- Old wear plates are installed. Remove and replace as per DSI 9440
- Put all hard ware back into stock under original BATCH #'s
- Pull stock to make Skid a CHG006 as per current IIN
- Needs new **BATCH** # to be put back into stock under
- Needs new paper work

# **RA 111225 D206-642-412 B41105**

## **CHG004**

### **Instructions to put skid tube back into stock**

- Remove (SCRAP) D2646 and replace with new one B# \_\_\_\_\_
- Old wear plates are installed. Remove and replace as per DSI 9440
- Put all hard ware back into stock under original BATCH #'s
- Pull stock to make Skid a CHG006 as per current IIN
- D206-648-011 was installed and needs to be scraped.
- Saddles were not in original wrappings. Need to be rewrapped under original B#
- Needs all ne paper work
- Needs new **BATCH** # to be put back into stock under



DART Aerospace Ltd

# CUSTOMER RETURN

#RA: 111225

Date: MAY 13, 2011

Initiator: M. BELLAVANCE  
 Company: UNITED ROTORCRAFT SOLUTIONS  
 Contact: JOHN BRIGHAM  
 Phone No.: 1 940 627 0626

Invoice #: WV104816  
 SO#: WV 50104 843

Attach Copy of DHS Return Authorization #: 00973

SQ#: \_\_\_\_\_ NCR#: \_\_\_\_\_ CSR#: \_\_\_\_\_ PAR#: \_\_\_\_\_

Reason for Return:

SEE ATTACHED

Receiving:

Date Received: 11/6/11 Freight Company: DAY PUS

Prepaid Collect

Qty	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
<u>1</u>	<u>D706-642-411</u>	<u>41103</u>	<u>SHROTCB</u>		
	<u>D706-642-412</u>	<u>41105</u>			

Condition of Packaging: GOOD / DE-411A

Photograph Required: yes ☐ no ☒

Paperwork Attached: P/S \_\_\_\_\_ Invoice ☒ ARC \_\_\_\_\_ Docs \_\_\_\_\_ Other parting

QC:

Quarantine Location: De Quarantia

Condition of Part: Sealed / Accepted / Damaged / Scrap

Inspectors Initial: S Date: 11/6/11

Photograph Required: yes ☐ no ☒

Qty	Part #	CHG #	Batch #	QC Comments	QC Approval		Scrap
					Initial	W/O#	
	<u>D706-642-411</u>	<u>001</u>	<u>41103</u>	<u>* See Attached instructions sheet.</u>	<u>A</u>	<u>70717</u>	
	<u>D706-642-412</u>	<u>004</u>	<u>41105</u>	<u>* See Attached instructions sheet.</u>	<u>A</u>	<u>70718</u>	

QA Coordinator:

Advise GM as to Findings: Initial: A Date: 11.06.11

Comments:

Issue Credit: yes ☒ no ☐

GM Approval: [Signature]

Date: 11/05/11

Invoice Amount: \_\_\_\_\_  
 Less Replacement: \_\_\_\_\_  
 Restock Fee: \_\_\_\_\_  
 Freight: \_\_\_\_\_  
 Net Credit: \$ 8185.18  
 DHS Customer

QA: Enter into Q-Pulse with Reason for Return & File original. Signed: \_\_\_\_\_ Date: \_\_\_\_\_

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
 32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
1	1		X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
1	1				X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
 32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
1	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
1	1				X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>HA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>HA</del>	TITLE	SCALE
DE APPR.	<del>HA</del>	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 32.16 206L/L-1/L-3/L-4 High Gear Skidtubes Parts List

Item	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	Part Number	Description
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-7	SKIDTUBE ASSEMBLY
2A			22			D2651-1	* PLUG <sup>(1)</sup>
2B			22			D2651-3	* O-RING <sup>(1)</sup>
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			MS27039-1-08	* SCREW <sup>(1)</sup>
5			2			AN960JD10L	* WASHER <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-11A (OR AN5-12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5-11A (OR AN5-13A)	* BOLT <sup>(2)</sup>
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2655-15)
22B			1	1		D3536-15	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2655-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)
24B			1	1		D3536-37	GASKET
26A			60	60		MS27039C1-08	SCREW
26B			60	60		AN960C10L	WASHER
26C			60			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	LUG ASSEMBLY (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

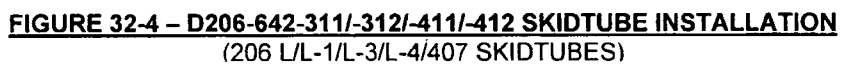
NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-7 ASSEMBLY ABOVE<sup>(2)</sup> CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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32-00-00

Revision: 3



**32-00-00**

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

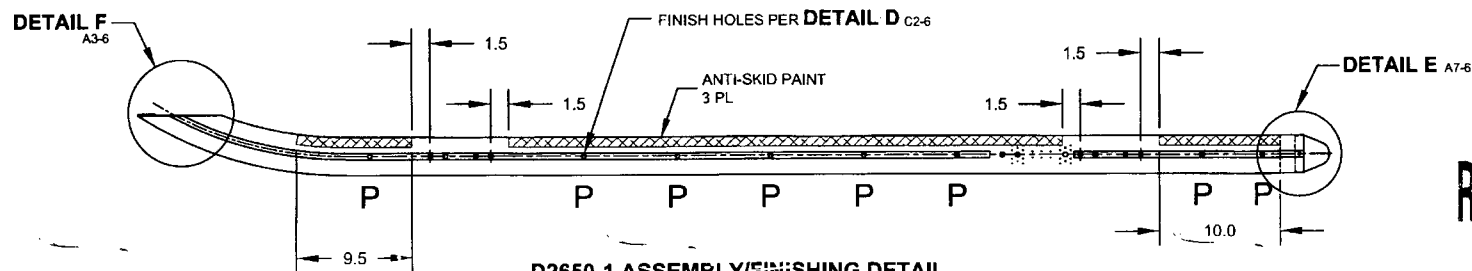
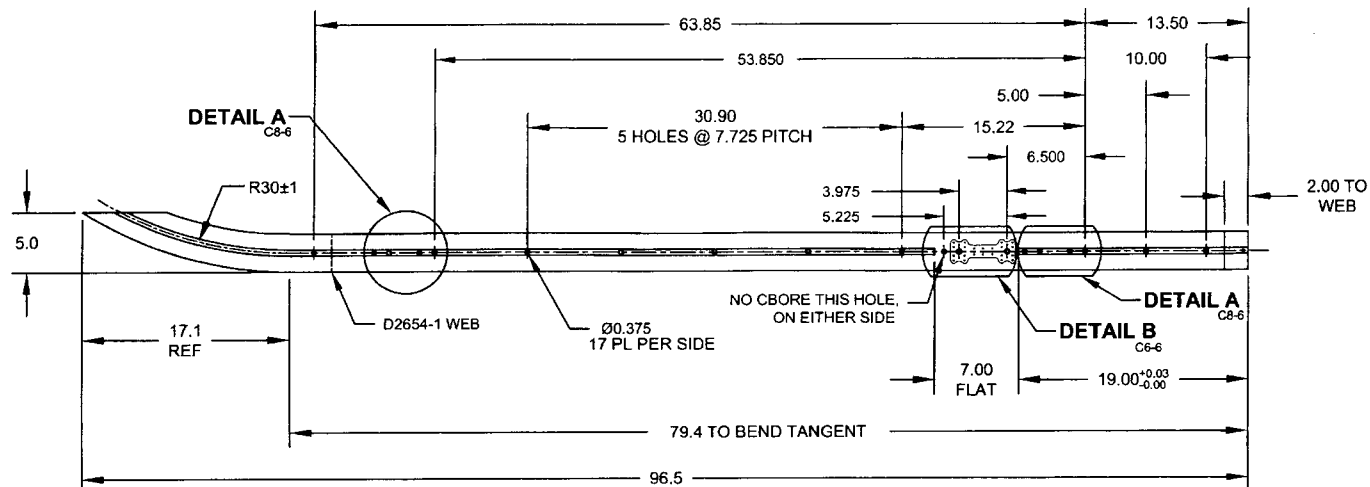
F

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

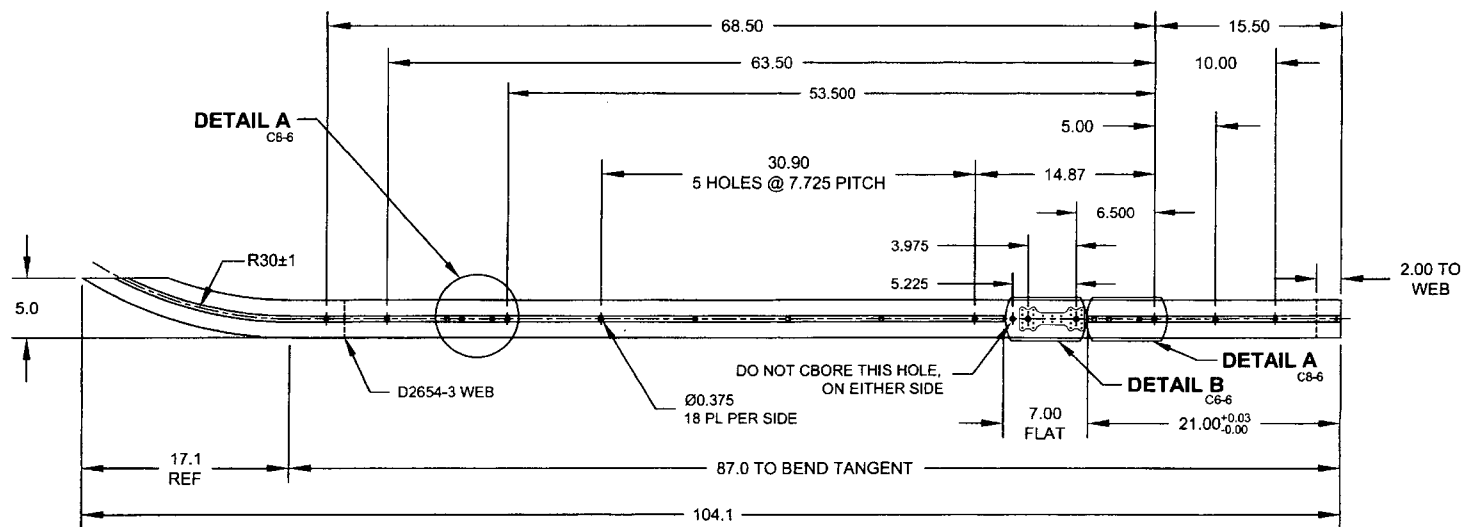
RELEASED  
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 1 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
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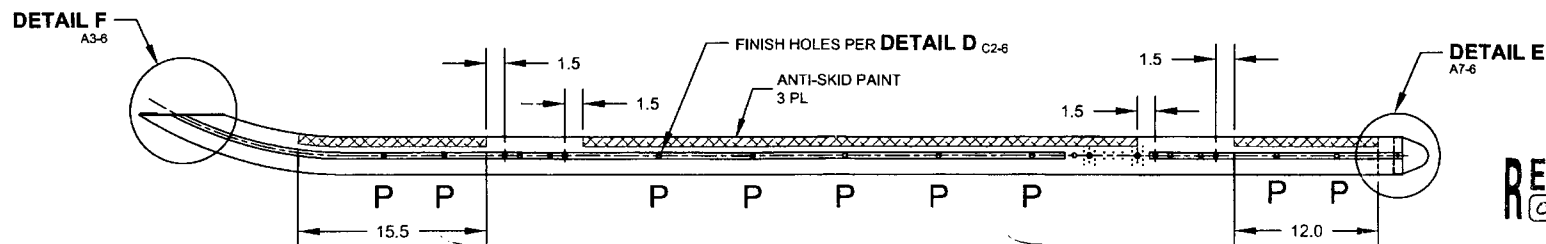


**RELEASED**  
680722/148

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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**D2650-3 BENDING/DRILLING DETAIL**



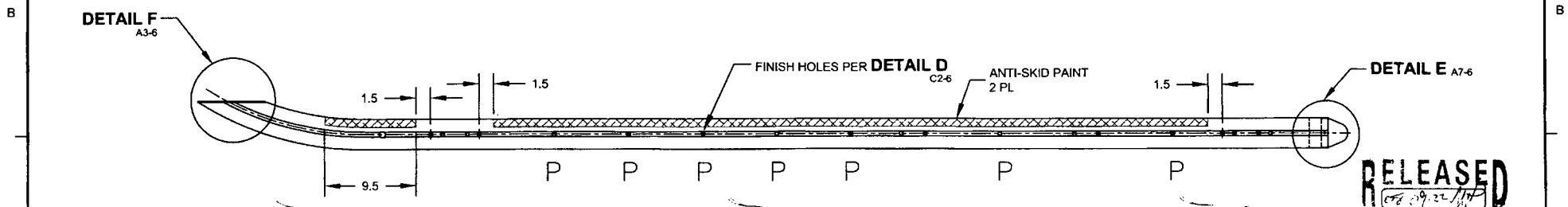
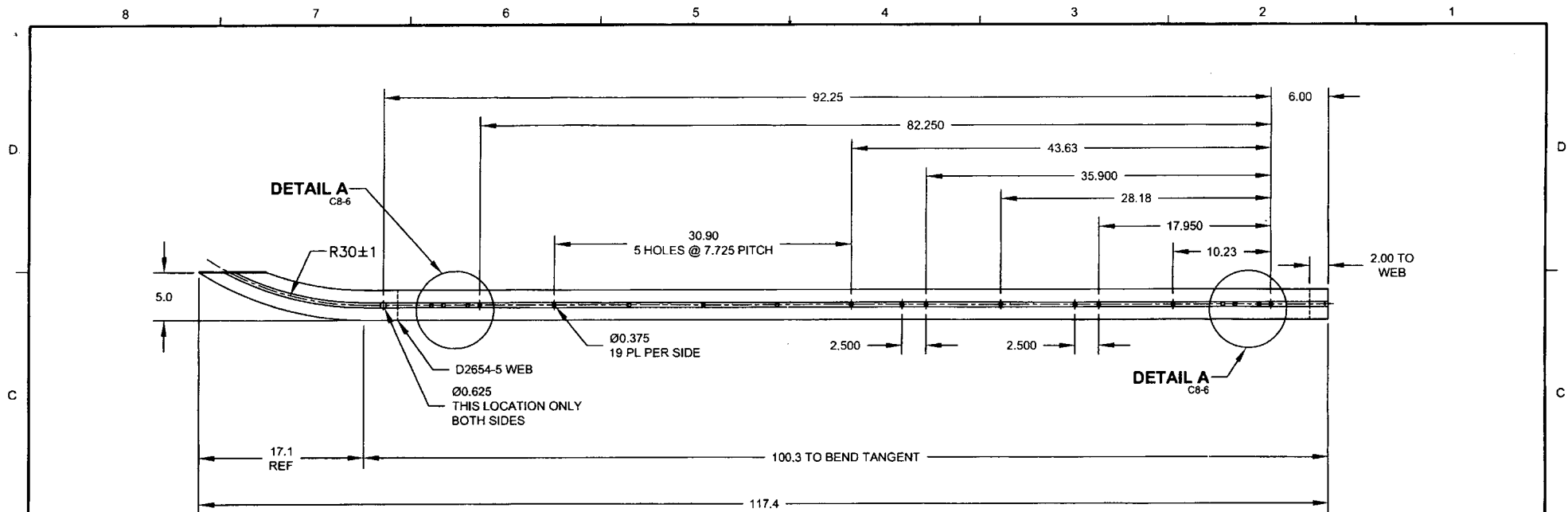
**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
05 07 22 100

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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2017

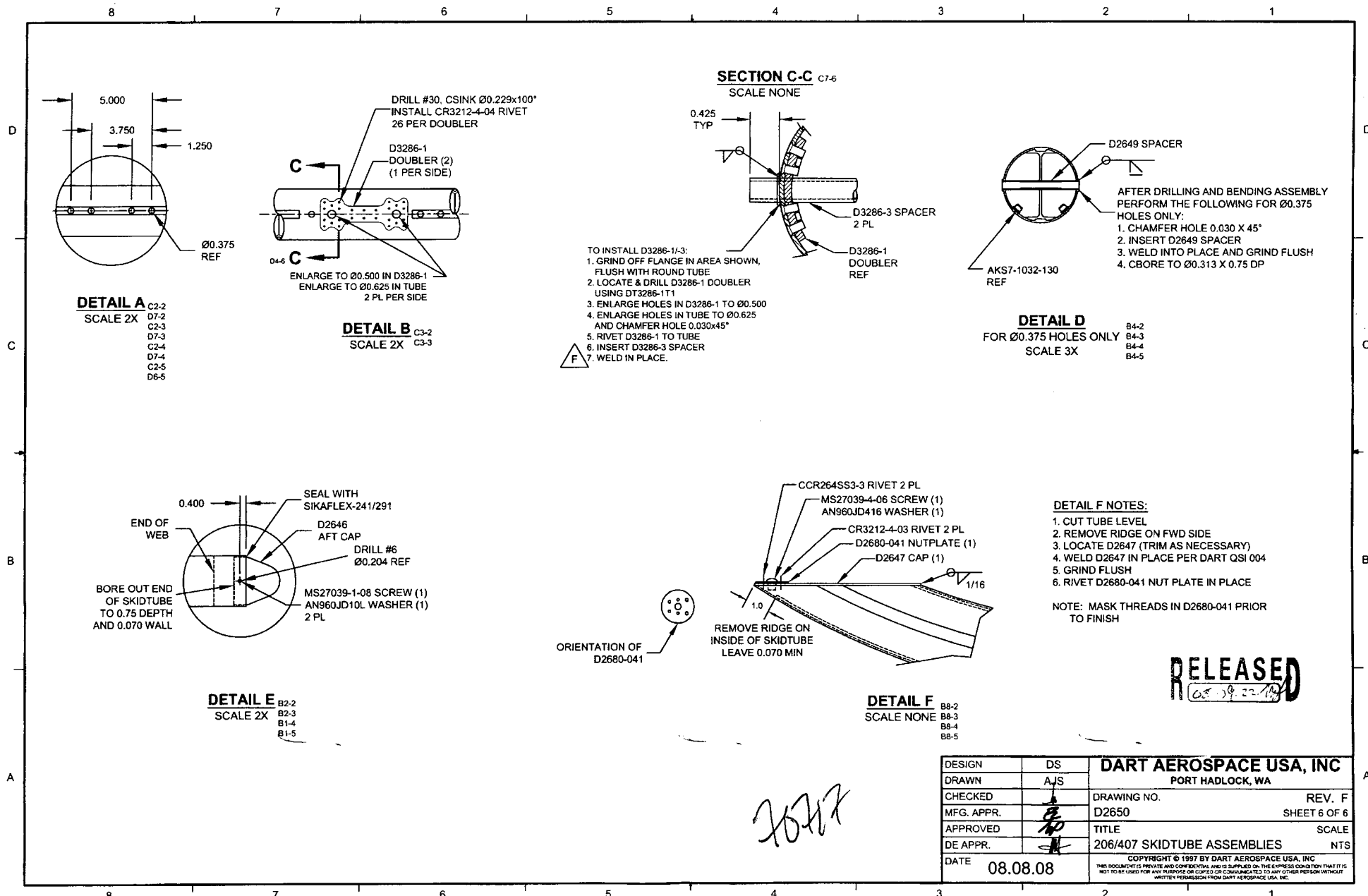




*70x17*

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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Date: Monday, 11/08/2008 10:15:17 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L/L3/L4 HIGH GEAR SKID
<b>Job Number</b> : 41105	
<b>Estimate Number</b> : 10526	
<b>P.O. Number</b> :	<b>Part Number</b> : D206642412
<b>This Issue</b> : 11/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 11/08/2008 <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : L
<b>Previous Run</b> : 41104	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/08/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 08.8.11	
<b>Comment</b> : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-05, ECN 1080p DD verified by:	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD 08.8.26

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-412 CHG004

08/08/29

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	41105A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------

**Comment:** Sub-Component 206 L HIGH GEAR SKIDTUBE

1 x D206-642-441 Batch 41105A

30

4.0	D206648011	GHW Modification
-----	------------	------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch: B40442

18 08/08/27 (x1)

5.0	D2652	Bushing
-----	-------	---------

**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2652 Bushing

1 D206-642-441(REF)

40556

18 08/08/27 (x1)

Date: Monday, 11/08/2008 10:15:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 41105

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655

Tow Ring

37378

AS 08/08/27 (X)

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

37765

AS 08/08/27 (X)

8.0

D29322

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-2

Saddle

40280

AS 08/08/27 (X)

9.0

D29332

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-2

Saddle

39157

AS 08/08/27 (X)

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

41130

AS 08/08/27 (X)

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

46282

AS 08/08/27 (X)

Date: Monday, 11/08/2008 10:15:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 41105

Part Number: D206642412

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	D29382	Saddle RH Out, 206
------	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2938-2 Saddle 39890

de

SS 08/08/27 @

13.0	D29392	Saddle RH In, 206
------	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2939-2 Saddle 39914

de

SS 08/08/27 @

14.0	D2968043	Tow Ring
------	----------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2968-043 Tow Ring 37380

return to sth

SS 08/08/27 @

15.0	AN341A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN3-41A Bolt 168302

de

SS 08/08/27 @

16.0	AN45A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-5A Bolt 106605

return to sth

SS 08/08/27 @

Date: Monday, 11/08/2008 10:15:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 41105

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

107534

18.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M108167

19.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt

M104885

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch

M108377

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer

M169059

New Batch

Date: Monday, 11/08/2008 10:15:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 41105

Part Number: D206642412

Job Number:



Seq. #: Machine Or Operation: Description :

22.0 AN960JD1016 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN960JD1016 Washer M 5519

*return to stock*

*SS 08/08/27*

23.0 AN960JD416 Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Qty Part Number Description Batch

25 AN960JD416 Washer M108601

*OK*

*SS 08/08/27*

24.0 AN960JD516 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 AN960JD516 Washer M108672

*OK*

*SS 08/08/27*

25.0 AN9704 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN970-4 Washer M108377

*return to stock*

*SS 08/08/27*

26.0 MS21042L3 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 MS21042L3 Nut (or -3) M108701

*OK*

*SS 08/08/27*

27.0 MS21042L4 Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) M107499

*OK*

*SS 08/08/27*



Date: Monday, 11/08/2008 10:15:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 41105

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/08/08/29/40

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-412

Location:

PPP Rev: C

8/8/08

(7)

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/02

Job Completion



MF 08-08-29

B41105A